

Page 1

Quality Control

20 0 OFC 2015-03-3

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 130883

130883

Page 3

March-26-15 1:26:45 PM

Item ID: D2873-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Nut Plate Assembly
 Start Date: 3/26/15 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 3/26/15 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160						(20)			15/04/15
HandFinish	Memo	0.01							
Hand Finishing									
170	QC7-Inspect Chemical Conversion Coat	0.00							DAS 36 9-89
170						(20)			
QC	Memo	0.00							
Quality Control									APR 15 2015
180	Small Fab	0.00							DAS 36 9-89
180						20x			15/04/15
Small Fab	Memo	0.01							
Small Fab	1-Assemble as per Dwg D2873 2-Identify as D2873-043								

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Work Order ID 130883

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130883

Page 4

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 Revision ID: Stop ***NS2***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				<u>20</u>			DAS 38 9-89 APR 17 2015
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>LG-052</u> Memo	0.00 0.00				<u>20</u>		DAS 06 9-89	 APR 17 2015
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.03				<u>MLJ</u>	<u>1504-20</u>		<u>MLJ 1504-17</u>

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Picklist Print

March-26-15 1:26:45 PM

Page 1

Work Order ID: 130883

130883

Parent Item: D2873-043

D2873-043

Parent Item Name: Nut Plate Assembly

Start Date: 3/26/15

Required Date: 3/26/15

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.375X01.00 0		Purchased	No			180	f	16.6190	0.3083	7			

M6061T6B0 375X01 000

6061T6 BAR .375 x 1.00

**

Location

Loc Qty

Loc Code

MAT001

16.619

m131226

13.9

m131392

2.719

MS20426AD4-6

Purchased

No

180

Each

1,498.000

6

MS20426AD4-6

Rivet

**

Location

Loc Qty

Loc Code

GA

904

M128812

904

MF4

185

124392

185

ST312

409

124392

83

M128812

326

MS21075L5

Purchased

No

100

Each

190.0000

3

MS21075L5

Nut Plate

**

Location

Loc Qty

Loc Code

GA

182

m128578

182

ST300

8

123346

8

5.7 JFC 2015-03-31
0.7
120/6.4
15/04/15
DAS 36 9-89

15/04/15
DAS 36 9-89

60

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DART AEROSPACE LTD		Work Order: 130883
Description: Radius Block		Part Number: D2873-3
Inspection Dwg: D2873 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.500	✓		Caliper	JFC-01
2.000	+/-0.010	2.000	✓			
0.750	+/-0.010	0.750	✓			
1.000	+/-0.010	1.000	✓			
0.250	+/-0.010	0.250	✓			
1.000	+/-0.010	1.000	✓			
2.000	+/-0.010	2.000	✓			
3.000	+/-0.010	3.000	✓			
Ø0.128	+0.005/-0.001	0.128	✓			
0.359	+/-0.010	0.359	✓			
Ø0.316	+0.006/-0.001	0.317	✓			
1.000	+/-0.010	0.998	✓			
0.250	+/-0.010	0.246	✓			
0.061	+/-0.010	0.061	✓		Caliper	JFC-01
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	0.225 x 0.125	✓		HB+Cal	31000+JFC-01

DAS

Measured by: JFC
Date: 2015-03-31

Audited by: 37 9-89
Date: 15.04.01

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	

